

# Work Order ID 90344

\*90344\*

Page 1

September-17-12 1:23:26 PM

Item ID: D4017-9

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rib

Start Date: 9/17/12 Start Qty: 10.00

\*10\*  
\*10\* (8x)

Cust Item ID:

Required Date: 10/05/12 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12-09-18 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4017	D

100 0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4017  
2- Deburr and remove identify marks

CC 12-11-21 (8x)

110

QC6- Inspect dimensions to drawing

0.00

\*110\*

QC

Memo

0.00

Quality Control

(8) 12-11-21

DAS  
09  
2-89

120

Identify as per dwg & Stock Location: W/A

0.00

\*120\*

Packaging

Memo

0.00

Packaging

CC 12-11-21 (8x)

**Work Order ID 90344****\*90344\***

Page 2

September-17-12 1:23:26 PM

Item ID: D4017-9

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib

Start Date: 9/17/12 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 10/05/12 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

12/11/22 *[Signature]*  
MF  
12-11-21

# Picklist Print

September-17-12 1:23:26 PM

Page 1

Work Order ID: 90344

Parent Item: D4017-9

Parent Item Name: Rib

Start Date: 9/17/12

Required Date: 10/05/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 11.01.17 chg qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	1,229.0001	2.28166	24.017474		CC 12-11-21	

## Location

## Loc Qty

## Loc Code

MAT018

643.930134

122413

643.930134

MAT034

585.0700153

118460

0.00001534

121808

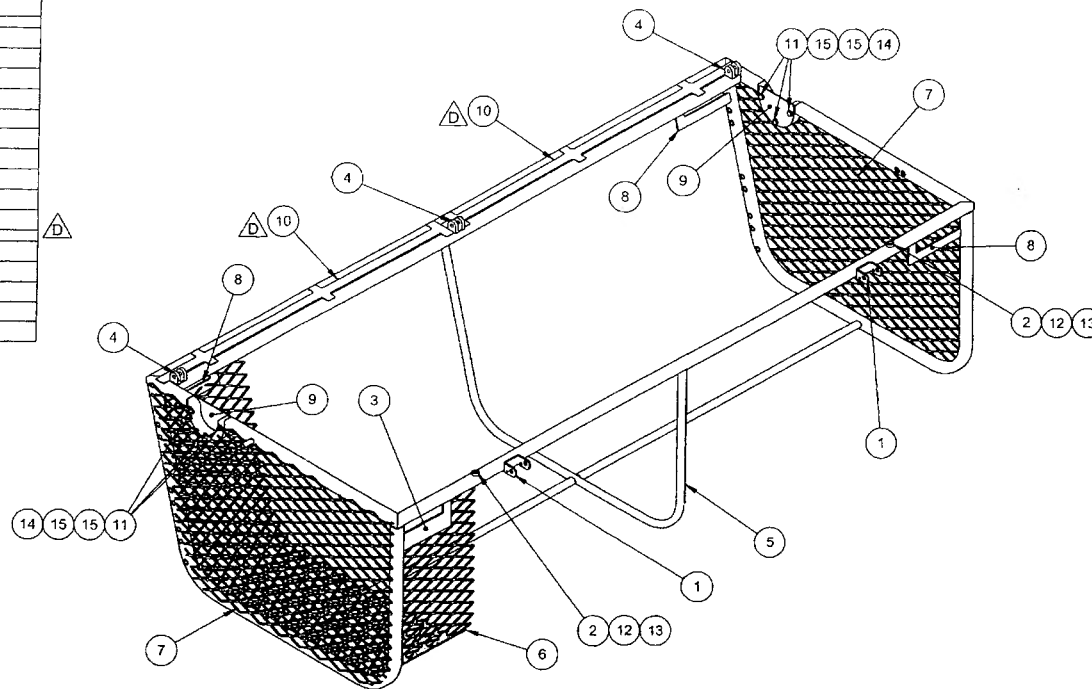
0.07

122938

585

19.2139792

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	3	D4016-1	HINGE HALF, BASE
5	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-3	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 90344 MLG  
12-09-18

**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

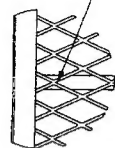
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2012-07-12  
PCN 12-610

B	ADD D4672-3 (ZN C5-1, D4-1, D6-1, D3-2, AND D4-2). REASON: PART 12-197.	MB	12.06.18
C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A. NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED, DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4017</b> REV. D SHEET 1 OF 5 TITLE <b>SHORT BASKET BASE ASSY (350)</b> NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	AS		
CHECKED	AS		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	12.06.18		

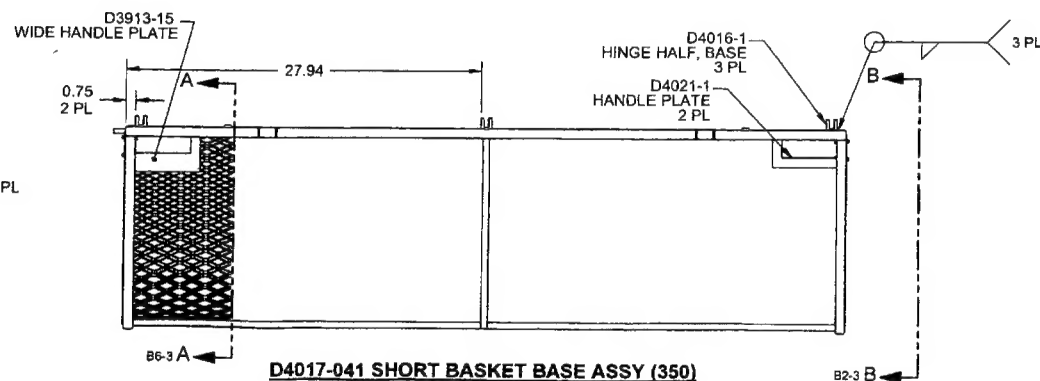
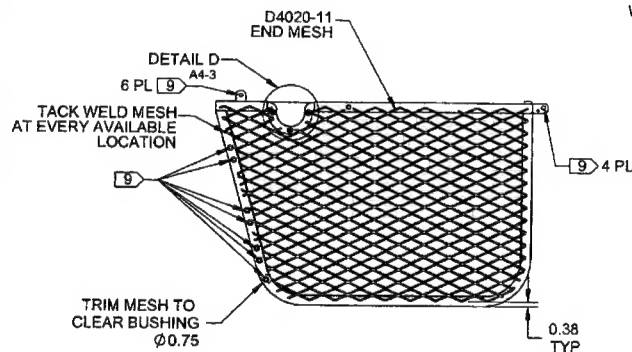
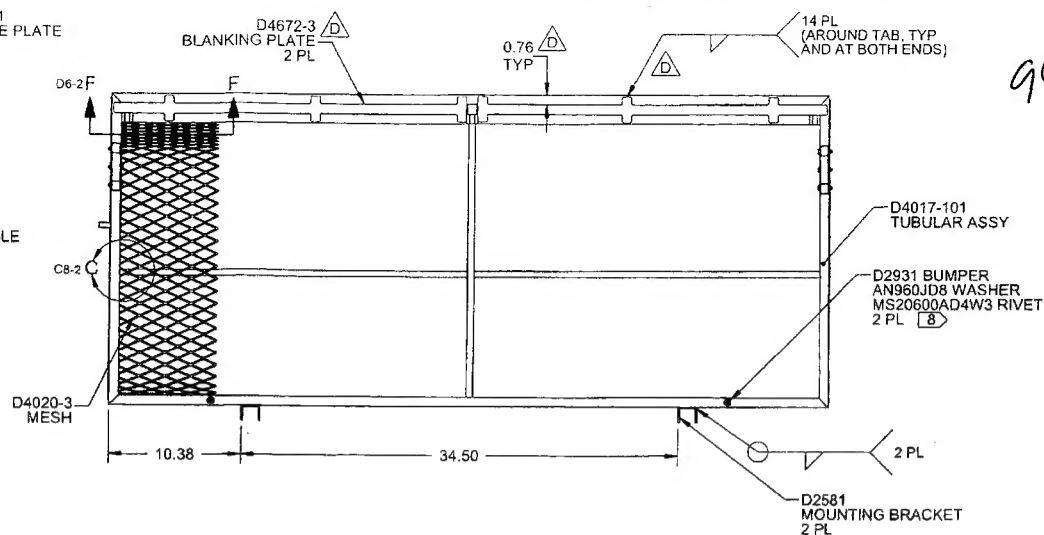
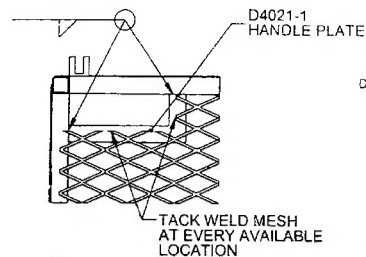
90344

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION



DETAIL C D6-2

SECTION F-F  
TYPICAL FOR ALL  
HANDLE PLATES

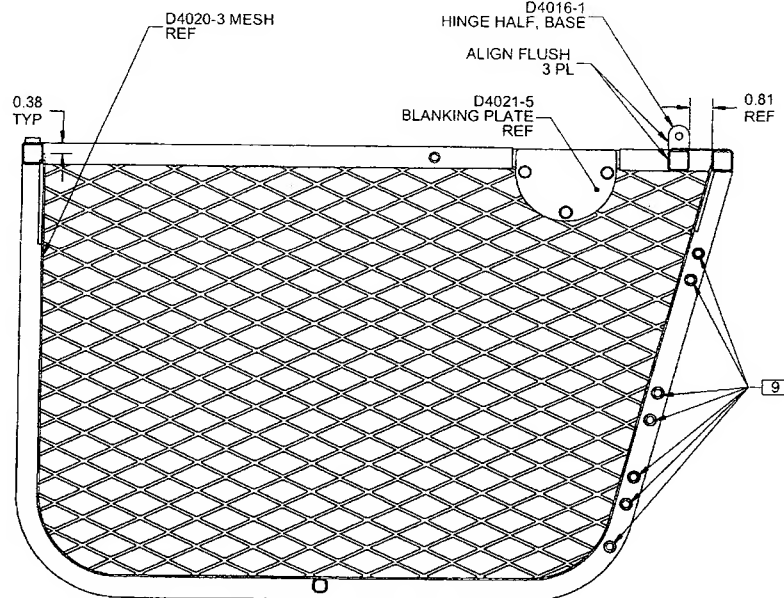


D4017-041 SHORT BASKET BASE ASSY (350)  
(MESH SHOWN LOCALLY FOR CLARITY)

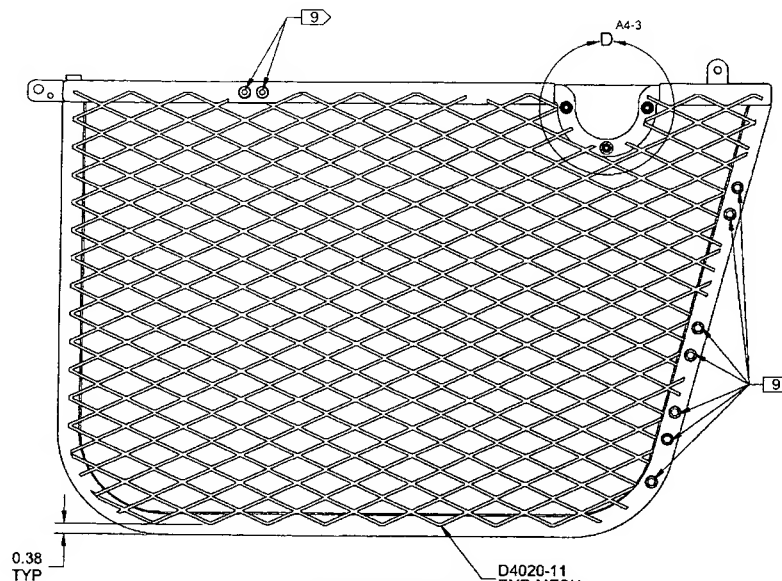
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2012-07-12  
97

DESIGN	AKS	DART AEROSPACE LTD
DRAWN	S	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P.	DRAWING NO. REV. D
MFG. APPR.		D4017 SHEET 2 OF 5
APPROVED		TITLE SCALE
DE APPR.		SHORT BASKET BASE ASSY (350) NTS
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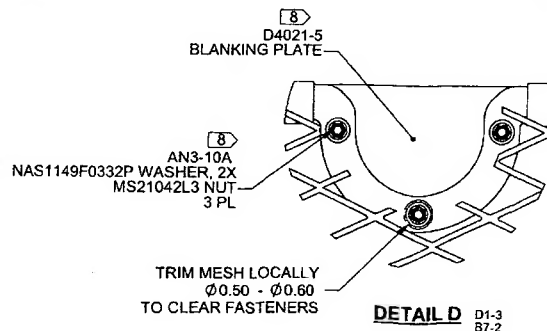
90344



**SECTION A-A** A5-2



**SECTION B-B** A2-2

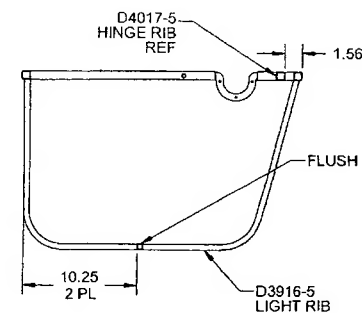
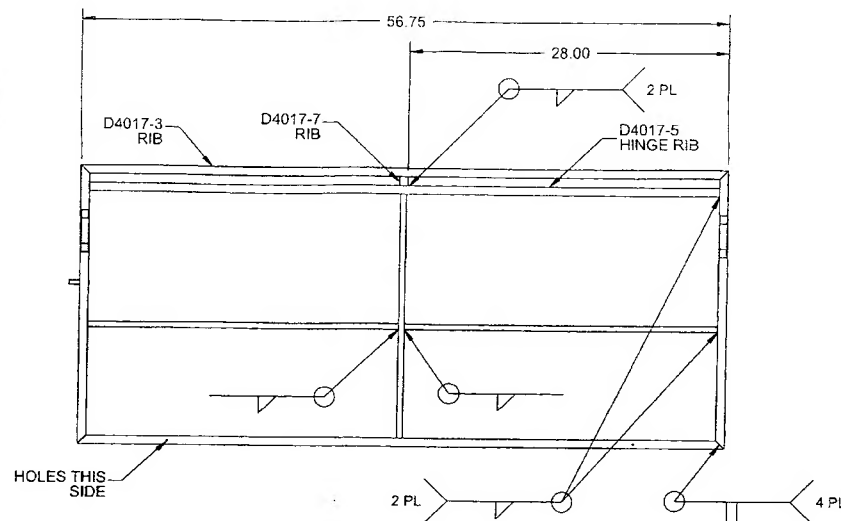


**DETAIL D** D1-3 B7-2

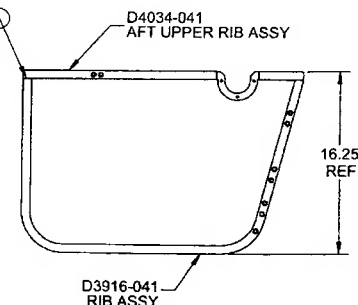
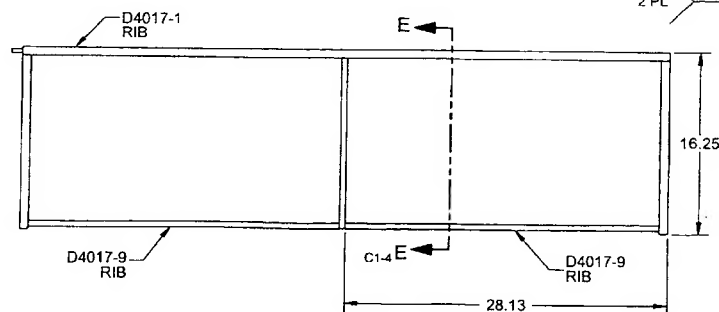
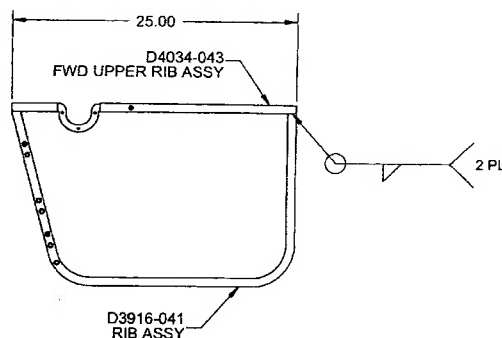
RELEASED  
2012-07-12  
4P

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	6	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO. <b>D4017</b>	REV. D
MFG. APPR.		SHEET 3 OF 5	
APPROVED		SCALE	
DE APPR.		<b>SHORT BASKET BASE ASSY (350) NTS</b>	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION E-E A4-4



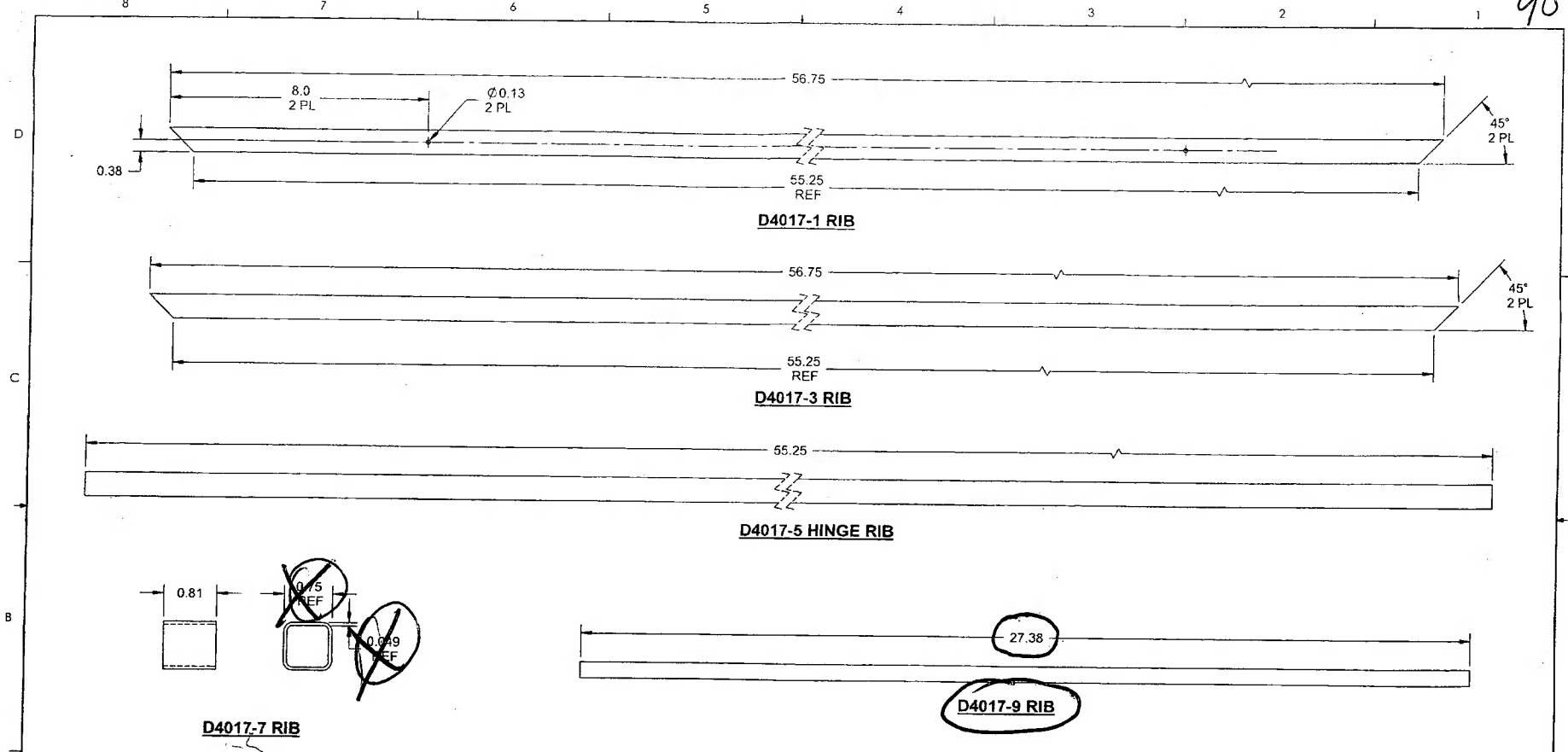
8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 15.26 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4017-101
  - 9) WELD PER DART QSI 004

RELEASED  
2012-07-12  
UP

DESIGN	ALS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. D
MFG. APPR.			D4017	SHEET 4 OF 5
APPROVED			TITLE	SCALE
DE APPR.			SHORT BASKET BASE ASSY (350)	NTS
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90344



NOTES:

1) MATERIAL -1 THRU -7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049

-9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED  
2012-07-12

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A.P.	DRAWING NO.	REV. D
CHECKED	A.P.	D4017	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		SHORT BASKET BASE ASSY (350)	NTS
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